

Date: Wednesday, 4/4/2007 9:14:55 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CLAMP  
 Job Number : 31632  
 Estimate Number : 12805  
 P.O. Number : N/A Part Number : D35561  
 This Issue : 4/4/2007 S.O. No. : N/A Drawing Number : D3556 UNDER REVIEW A E  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : N/A E  
 Previous Run : N/A Material : N/A  
 Due Date : 4/30/2007 Qty: 80 Um: Each  
 Written By :  
 Checked & Approved By :  
 Comment : Est Rev:A New Issue 07-03-23 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 3462

C207104/05

(80)

Cut &amp; Form as per Dwg D3556

Material release note is required

2.0 D35561 Clamp



Comment: Qty.: 1.0000 Each(s)/Unit - Total : 40.0000 Each(s)

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive &amp; Inspect for Transit Damage

Ensure Material Release Note is attached

Pc 7/5/01

(80)

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg 92498

D3556

80 - counted

QSP019

N/A (6.788" center to center)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Tumble &amp; Deburr any rough edges

SAD

07/05/02

(80)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/05/03

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

Date & initial all entries

Date: Wednesday, 4/4/2007 9:14:55 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 31632

Part Number: D35561

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/05/02

80

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

PO 7/5/02 (80)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(80)

Comment: FINAL INSPECTION/W/O RELEASE

07/05/03

Job Completion



U 07/05/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

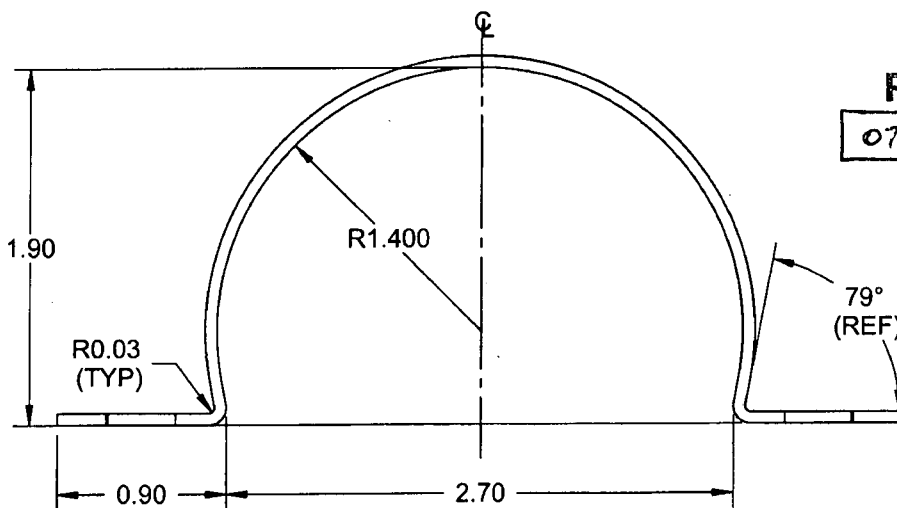
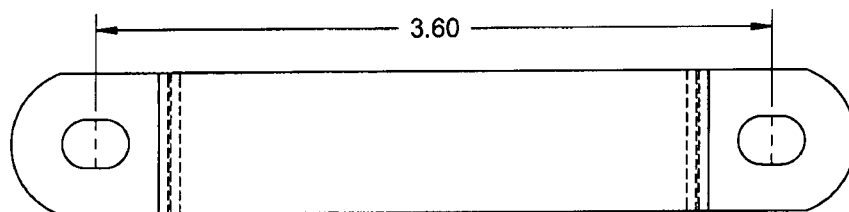
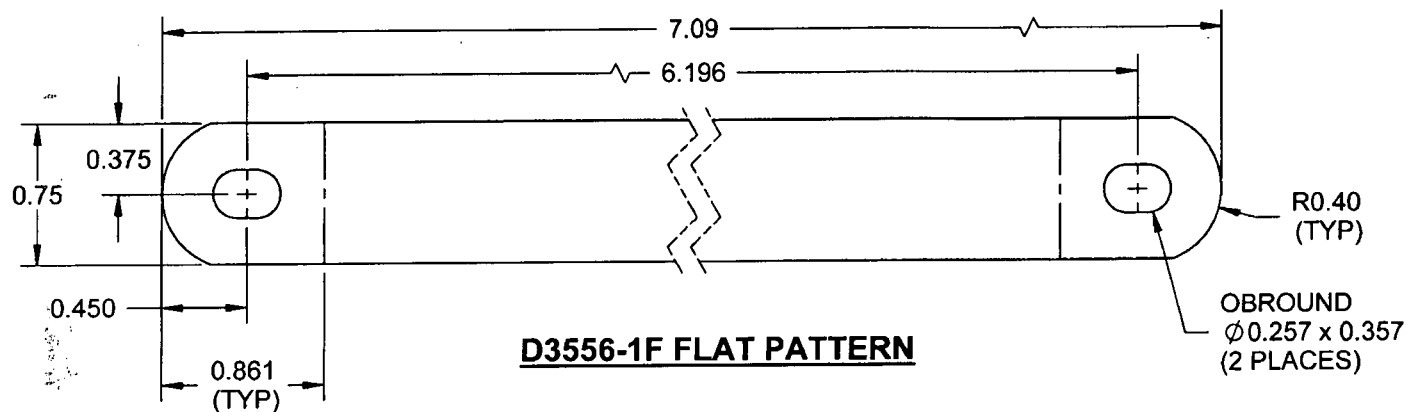
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3556	REV. A SHEET 1 OF 1
DATE 07.02.13		TITLE CLAMP	SCALE 1:1
REV A	DATE 07.02.13	DESCRIPTION NEW ISSUE	



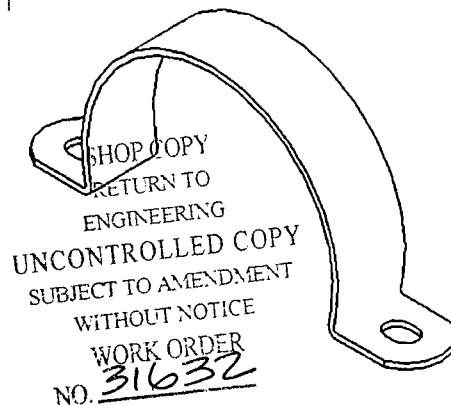
RELEASED

07.03.08 [Signature]

**D3556-1 CLAMP**

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE, PER MIL-S-5019 (REF DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N D3556-1 USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT Φ



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CERTIFICATE OF COMPLIANCE  
CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE  
POINTE CLAIRE, QC  
H9R 1A1

**DART AEROSPACE LTD**  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7

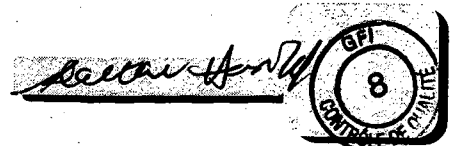
CERTIFICATE NO.	1	OUR JOB NO	J0160592	SHIPPING MEMO	0363732	
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
-	80 PCS	PO00003462	D35561	A	CLAMP	A
MATERIAL		SUPPLIED BY		MAT. REL. NO.		
SST 304 / 316		SIGMA METALS / A K STEEL		H/N # 7361663		

	PROCESS	PROCESSOR	RELEASE NOTE #
1	FIRST ARTICLE INSPECTION REPORT ON FILE	GFI	CONFORMS
2			
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 27 APRIL 2007

G.F.I. Q.C. REP.



288-07



**Sigma Metals Inc.**  
**45 Jefryn Blvd.**  
**Deer Park, NY 11729**  
*A Small Woman Owned Business*

(631) 243-2100 • (800) 471-7890 • Fax: (631) 243-3426

# Packing Slip

DATE INVOICE NO.  
 4/2/2007 43543

## BILL TO

GFI INC.  
 180 AVENUE LABROSSE  
 POINT-CLAIRE  
 QUE, CANADA  
 H9R 1A1

## SHIP TO

GFI INC.  
 180 AVENUE LABROSSE  
 POINT-CLAIRE  
 QUE, CANADA  
 H9R 1A1

P.O. NO.	TERMS	REP	SHIP VIA	FOB	SALES ORDER
0071346	Net 30	MEC	YELLOW	DEER PARK, NY	59881

ITEM	DESCRIPTION	QTY
SS T304	304 STAINLESS STEEL SHEET ANNEALED AMS 5513 .063" X 48" X 96" 168 LBS. MILL: AK STEEL LOT# 7361663 PRICED PER PC	2
	DOMESTIC CUSHPAK	1



**GFI INC.**

LE MATÉRIEL REÇU NE SERA ACCEPTÉ  
 QU'APRÈS VÉRIFICATION DE DIMENSIONS,  
 ÉPAISSEUR, POIDS ET CONDITIONS.

SIGNATURE [Signature] DATE 05 APR 07

### CERTIFICATE OF COMPLIANCE

THE WILLFUL RECORDING OF FALSE, FICTITIOUS OR FRAUDULENT  
 STATEMENTS ON THIS DOCUMENT MAY RESULT IN PUNISHMENT AS A  
 FELONY UNDER FEDERAL STATUTES. THIS DOCUMENT CERTIFIES THAT  
 ALL ITEMS NOTED ABOVE ARE IN CONFORMANCE WITH THE CONTRACT  
 DRAWINGS, SPECIFICATIONS AND OTHER DOCUMENTATION. ALL  
 REQUIRED PROCESS CERTIFICATION AND CHEMICAL AND PHYSICAL TEST  
 REPORTS ARE ON FILE IN THE FACILITY AND ARE SUBJECT TO REVIEW

THIS MATERIAL MEETS ALL SPECIFICATIONS LISTED

GREG SALADINO, QC

Gregory Saladino

Quality Control Manager

ORDER COMPLETE - TEST REPORTS WITH SHIPMENT  
 WE NOW ACCEPT VISA, MASTERCARD, AND AMERICAN EXPRESS



AK Steel Corporation  
Metallurgical Test Report  
Coshocton Works  
Coshocton, OH 43812

Page 1

Load No. 8304809  
SRN No. 8304809

MILL ORDER NO. 271940-0798  
PROCESSOR ORDER NO. 01009471

PART NO.  
00640

ENGLISH UNITS --PRODUCT-- METRIC UNITS  
.0620 NOM 48.0000 X COIL

SKID ID	PIECE	HEAT	PARENT COIL ID	NET WEIGHT
SKD799032	1	7361663	0808293-02	16,080 LBS. 7,294 KG.
SKD799033	1	7361663	0808293-02	18,010 LBS. 8,169 KG.
TOTAL SKIDS	TOTAL PIECES			TOTAL NET WEIGHT
2	2			34,090 LBS. 15,463 KG.

L-Ladle Analysis of Heat

P-Product Analysis of Parent Coil

CHEMICAL ANALYSIS

ID	C	MN	P	S	SI	CR	NI	MO	N	CU						
L 7361663	.016	1.30	.028	.001	.45	18.35	8.58	.35	.036	.41						

SHIPPING DATE: 02/07/2007

REMARKS:

THIS MATERIAL WAS MELTED AND MANUFACTURED IN THE U.S.A.  
NO INTENTIONAL ADDITIONS OF MERCURY OR MERCURY COMPOUNDS, RADIUM, ALPHA  
SOURCE, AND LOW MELTING ALLOYS OR ELEMENTS CAPABLE OF FORMING LOW MELTING  
ALLOYS WERE MADE THROUGHOUT THE PROCESSING OF THIS MATERIAL.  
COILED PRODUCTS CONTAIN NO WELDS  
DEEP DRAW QUALITY

PRODUCT DESCRIPTION

CR SHT TYPE 302/304/304L STAINLESS #2B FINISH SLIT EDGE \* AMS 5513 H \* ASTM A 240 -06 (UNS S30400). \* AMS 5511 H \* AMS 5516 N \*  
ASTM A 666 -03 \* MILS-5059 D-AMEND-3 \* UNS-S30403 9TH EDITION \* FMI-304L/304/302 ISSUE 7, 2/13/06 \* ASME SA-240 SECTION II PAR  
T A (2004 ED, 2005 ADDENDA) EX PARA 3.1.7 DIMENSIONAL TOLS FROM ASME SA-480 2004 ED APPLY \* UNS-S30400/S30200

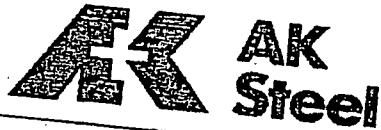
PARENT COIL ID	POS (F/T)	DIR (L, T, D)	COND	% ELONG 2 INCH MEASURED	TENSILE STRENGTH (KSI)	Y.S. .2% OFFSET (KSI)	ROCKWELL HARDNESS Tall	ROCKWELL HARDNESS Front			
0808293-02	T	T	A.S.T.M	60.0	83.7	36.1	B 78	B 76			

REVIEWED BY Q.C.

Date 2/8/07 by *en*

\*\*\* CONTINUED ON NEXT PAGE \*\*\*





AK Steel Corporation  
Metallurgical Test Report  
Coshocton Works  
Coshocton, OH 43812

Page 2

Load No. 8304809  
SRN No. 8304809

MILL ORDER NO. 271940-0798  
PROCESSOR ORDER NO. 01009471

PART NO. 00640

ENGLISH UNITS --PRODUCT:-- METRIC UNITS  
.0620 NOM 48.0000 X COIL

PARENT COIL ID	POS (F/T)	DIR (L, T, D)	COND	ASTM A 262 PRACTICE E	GRAIN SIZE ASTM E112	BEND 180 IT					
0808293-02	T			PASS	8.00	PASS					
0808293-02	F			PASS	8.00	PASS					

SIGMA METALS INC.  
THESE TEST REPORTS APPLY TO:

P.O. 0071346  
S/O 59881  
PCS. 2  
NET 168# FTG DATE 4.2.07

THE CHEMICAL ANALYSIS AND PHYSICAL OR MECHANICAL TESTS REPORTED ABOVE ARE CORRECT  
CONTAINED IN THE RECORDS OF THE CORPORATION.

TESTING IS DONE IN ACCORDANCE WITH A.S.T.M. STANDARDS UNLESS OTHERWISE NOTED

Steel Corporation

04/02/07 5:39

"THIS CERTIFIED TEST REPORT HAS BEEN DELIVERED TO A CONSIGNEE OF MATERIAL PURCHASED FROM AK Steel Corporation. TO AVOID THE POSSIBILITY OF ITS MISUSE ON DELIVERY OF THE REPORT TO A THIRD PARTY IT MUST BE RE-CERTIFIED BY AND UNDER THE NAME OF SUCH CONSIGNEE"

SIGNED

APPLICATION ENGINEER

DATE 02/08/2007 TIME 05:27 AM